

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017314**Date Inspected:** 09-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 1

This QA observed ZPMC qualified welding personnel identified as 215082 perform Flux Cored Arc Welding (FCAW) Process on weld joint E2-SB1D-021-132,133. ZPMC Quality Control Personnel (QC) identified as Mr. Ai wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2133.

OBG # BAY 4

This QA observed ZPMC qualified welding personnel identified as 050502 perform Submerged Arc Welding (SAW) Process on weld joint SA3359-001-001. ZPMC Quality Control Personnel (QC) identified as Mr. Yang xu was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

This QA observed ZPMC qualified welding personnel identified as 207288 perform Submerged Arc Welding (SAW) Process on weld joint SA3357-001-001. ZPMC Quality Control Personnel (QC) identified as Mr. Yang xu

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was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 215960 perform Submerged Arc Welding (SAW) Process on weld joint CB3003B-018-002. ZPMC Quality Control Personnel (QC) identified as Mr. Zheng Zhi Wei was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2.

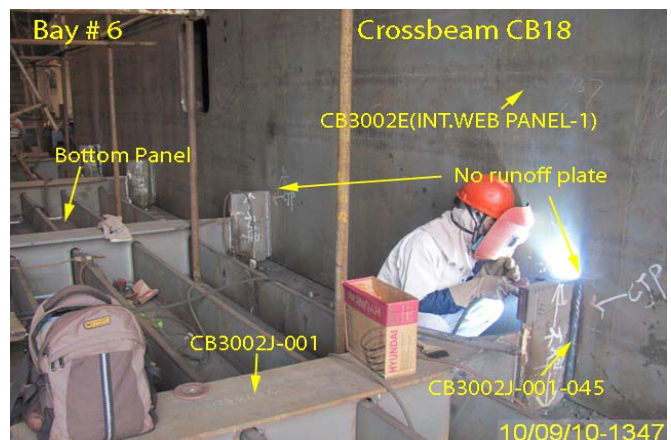
During random in process inspection, this QA observed that Welding has been performed on Complete Joint Penetration (CJP) welds without the use of runoff tabs. The affected welds are identified as CB3002J-001-welds 021 and 045, CB3002J-002-welds 021 and 045, CB3002K-003-welds 021 and 045 and CB3002K-004-welds 021 and 045. The welds are Complete Joint penetration (CJP) joints, joining the Intermediate web panel-1 (FB4107-001) to the Floor beam Diaphragm identified as CB3002J-001. This QA notified ZPMC Certified Welding Inspector (CWI) identified as Mr. Xu Xiang Ping of this issue and that an incident report would be generated. See attached pictures.

OBG # BAY 8

This QA observed ZPMC qualified welding personnel identified as 054459 perform Flux Cored Arc Welding (FCAW) Process on weld joint BK004A5-058-090. ZPMC Quality Control Personnel (QC) identified as Mr. Liu fa wen was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-U2-F.

This QA observed ZPMC qualified welding personnel identified as 500479 perform Flux Cored Arc Welding (FCAW) Process on weld joint BK004A2-053-016. ZPMC Quality Control Personnel (QC) identified as Mr. Liu fa wen was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2231-B-L1b-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

Inspected By:	Sukanthan,Dhanasingh
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Quality Assurance Inspector

Reviewed By:	Hall,Steven
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QA Reviewer
